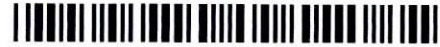




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2806-1
Job Sheet 175943



Part No: D2806-1

Job Qty: 24 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP: B 05.03.11 Part now turned KJ/JLM IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		5/19/18	0.00	0.00	Start Up Machining-1		
100	Doosan	24 pcs		5/19/18	0.00	2.51	Doosan		
120	QC	24 pcs		5/19/18	0.00	0.00	QC8		
130	HandFinish	24 pcs		5/21/18	0.00	0.32	HandFinish1		
140	QC	24 pcs		5/21/18	0.00	0.00	QC7-1		
150	Packaging	24 pcs		5/21/18	0.00	0.00	Packaging3-1		
160	QC21-SA	24 Ea		5/21/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1- Turn as per Folio FA105 Rev: _____ & Dwg D2806 Rev: _____ 2-Deburr per dwg D2806

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6H1.000	6061-T6 Hexbar 1.00	2.1984 ft (.0916 ea)	90-Start up Operation	M136687

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6H1.000	2	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	1.000inches $\pm$ 0.010	1.010 0.990		
2	Bushing	1.155inches $\pm$ 0.010	1.165 1.145		
3	Bushing	0.250inches $\pm$ 0.010	0.260 0.240		
4	Bushing	0.063inches $\pm$ 0.010	0.073 0.053		
5	Bushing	45.000Degrees $\pm$ 0.000	45.000 45.000		
6	Bushing	0.080inches $\pm$ 0.010	0.090 0.070		
7	Bushing	45.000Degrees $\pm$ 0.000	45.000		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

				45.000
8	Bushing	0.495inches	+ 0.000 - 0.005	0.495 0.490
9	Bushing	0.750inches	+ 0.000 - 0.005	0.750 0.745
10	Bushing	0.257inches	+ 0.005 - 0.000	0.262 0.257
11	Bushing	0.094inches	± 0.010	0.104 0.084

Plex 4/12/18 12:43 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Root Cause Container No: S100879 Part: D2806-1 Job No: 175943 Serial No/Batch: S100879 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				